

Work Order ID 162328

Friday, June 02, 2017 10:17:13 AM

162328

Page 1

Item ID: D5336-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Basket Lid Assembly, LH
Start Date: 6/28/2017 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/5/2017 Req'd Qty: 1.00 ***1*** Customer:
Reference: SCHEDULED/C

Approvals: Process Plan:  Date: JUN 02 2017 Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D5336	B

100

Weld per dwg A/R S.S. rod Batch: **4136695** 0.00
Large Fab

100

Large Fab

Large Fab

Memo

2.03

- 1- Assemble ribs , weld as per dwg D5336 using DT10196
- 2- Weld hinge (2) and locking brackets as per dwg D5336
inspect before welding mesh
- 3- Cut mesh as per dwg D5334-3
- 4- Tack weld mesh on basket as per dwg D5336
Make sure to place mesh correctly on lid, check with label plate before tacking mesh

DAS
43
9-89**JUL 02 2017****1x**

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

① 17-07-04**DAS**
9
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	☐ Pressure/Forced	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	☐ Bending	☐ Set-up	☐ Folio/Program	☐ Outside Dimensions		
Doc/Data ☐	☐ Offset/Setup	☐ Centre Not Concentric	☐ BOM/Route	☐ Grain	☐ Over/Under tolerance		
Equip/Tooling ☐	☐ Supplier	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Part Incorrect		
Handling/Pre ☐	☐ Training	☐ Crimp/Kink/Ripple/Wave	☐ Inspection Incomplete/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing		
Material ☐	☐ Use for Testing	☐ Cuffs	☐ Contamination	☐ Out of Sequence	☐ Part Moved		
Internal Transport ☐	☐ Poor Information	☐ Crushing	☐ Countersink	☐ Off-set	☐ Drawing		
Tribal Knowledge ☐	☐ Rushing	☐ Heat Treat	☐ Cut Too Short	☐ Misabeled	☐ Finish		
LOA ☐	☐ Product Improvement	☐ Wave/Twist in Tube	☐ Instructions Incomplete/Unclear	☐ Fit/Function	☐ Misread		
Substation ☐	☐ Process Improvement	☐ Marks/Chatter	☐ Drill Holes	☐ Misaligned/off center	☐ Turning Sequence		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

DQA: _____ Date: _____



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Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

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Page 3

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150									DAS
QC	Memo	0.01				1			38
Quality Control									9-88
									JUL 14 2017
160	Identify as per dwg & Stock Location: <u>u/c</u>	0.00							
160									
Packaging	Memo	0.01				12	1	10	6/2/12
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.10							17/7/2017
Quality Control									

JUL 19 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____	
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Picklist Print

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Page 1

Work Order ID: 162328

162328

Parent Item: D5336-043

D5336-043

Parent Item Name: Basket Lid Assembly, LH

Start Date: 6/28/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.10.15 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4016-3

Manufactured No

100

Each

104.0000

2

2

D4016-3

Hinge Half, Lid

** B159554 → 2x

DAS
43
9-89

JUN 27 2017

Location

Loc Qty

Loc Code

WA004

104

155384

5

159554

29

159570

20

160518

50

D5333-1

Manufactured No

100

Each

10.0000

1

1

D5333-1

Locking Bracket

** B159811 → 1x

DAS
43
9-89

JUN 27 2017

Location

Loc Qty

Loc Code

WA004

10

159811

10

M304EX0.75-16F

Purchased No

100

sf

513.5000

4.8

5.052632

M304FX0 75-16F

Expanded Metal Flat SS

** DG 2017-06-28

Location

Loc Qty

Loc Code

WA004

513.5

M136991

13.9

M137421

36.6

M137491

463

B137294 → 5.5

DQA: _____ Date: _____



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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
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Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : ☐							

Picklist Print

Friday, June 02, 2017 10:17:12 AM

Page 2

Work Order ID: 162328

162328

Parent Item: D5336-043

D5336-043

Parent Item Name: Basket Lid Assembly, LH

Start Date: 6/28/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D5332-043

Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5332-043*

Rib Assembly

**B159812 → 1x DAS 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

1

159812

1

D5332-7

Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5332-7*

Rib

**B163100 → 1x DAS 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

1

159813

1

D5332-9

Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5332-9*

Rib

**B159814 → 1x DAS 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

1

159814

1

D5332-11

Manufactured No

100 Each

1.0000

1 1

DAS

✓ *D5332-11*

Rib

**B159815 → 1x DAS 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

1

159815

1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER : ☐									

Picklist Print

Friday, June 02, 2017 10:17:12 AM

Page 3

Work Order ID: 162328

162328

Parent Item: D5336-043

D5336-043

Parent Item Name: Basket Lid Assembly, LH

Start Date: 6/28/2017

Required Date: 7/5/2017

Start Qty: 1.00

Required Qty: 1.00

D5332-15

Manufactured No

100 Each

3.0000

1 1

DAS

✓ ***D5332-15***

Rib

**B159822 → 1x 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

3

159816

1

159822

2

D5332-17

Manufactured No

100 Each

2.0000

2 2

DAS

✓ ***D5332-17***

Rib

**B163097 → 2x 43 JUN 27 2017
9-89

Location

Loc Qty

Loc Code

WA004

2

159817

2

DQA: _____ Date: _____



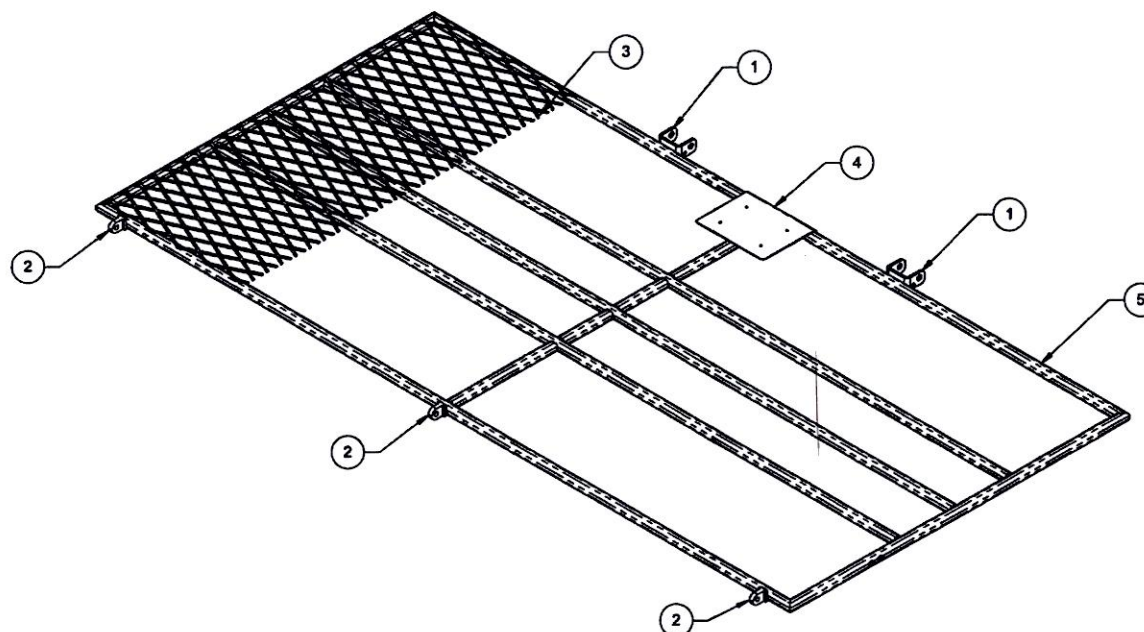
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

ITEM	QTY -041	P/N	DESCRIPTION
	X	D5336-041	BASKET LID ASSY
1	2	D2581	MOUNTING BRACKET
2	3	D4016-3	HINGE HALF, LID
3	1	D5334-1	LID MESH
4	1	D5335-1	DATA PLATE
5	1	D5336-101	TUBULAR ASSEMBLY, LID



D5336-041 BASKET LID ASSY 
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 12.0 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5336-041
- 10) WELD PER DART QSI 004

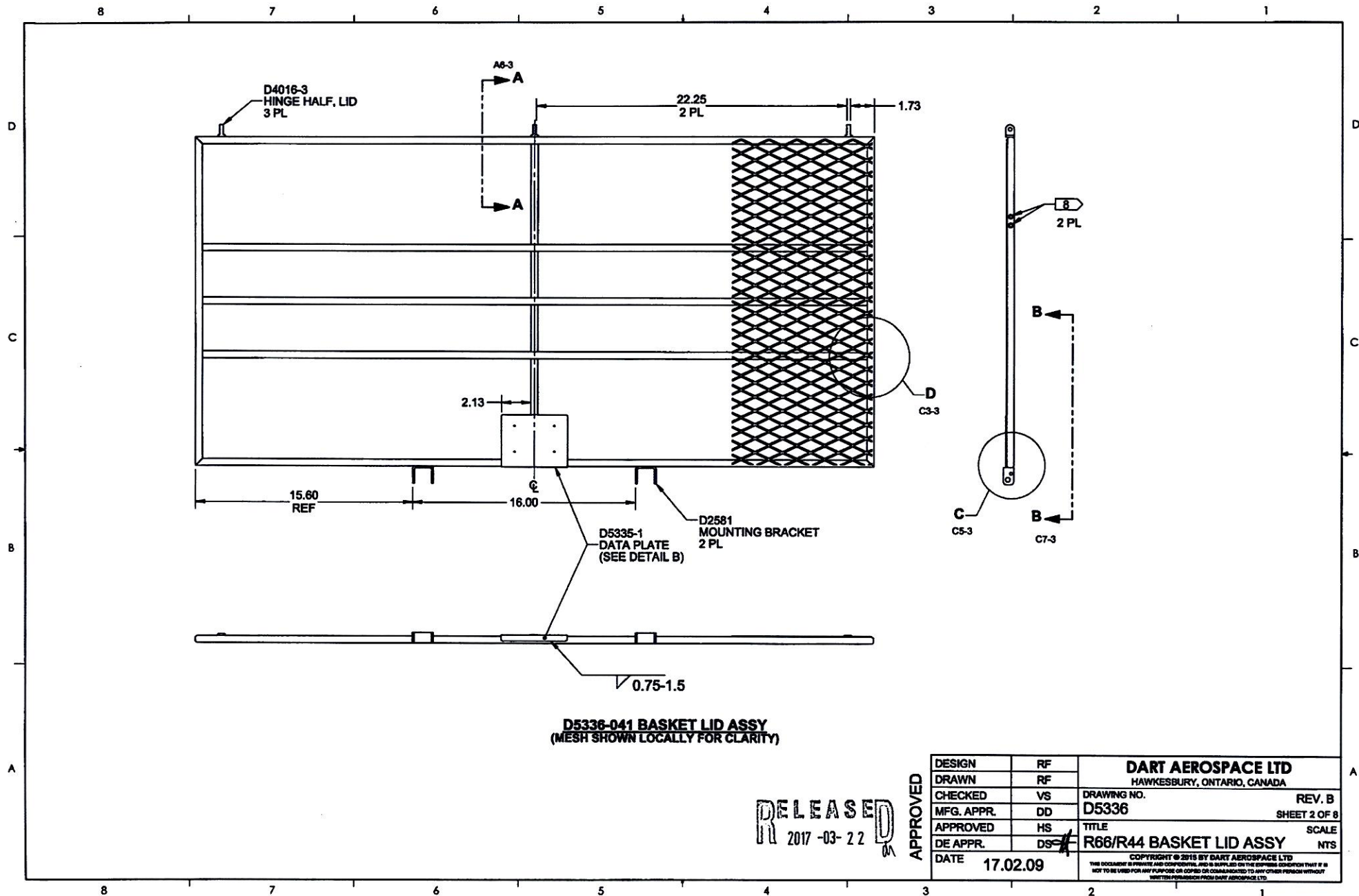
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 162328

JUN 02 2017

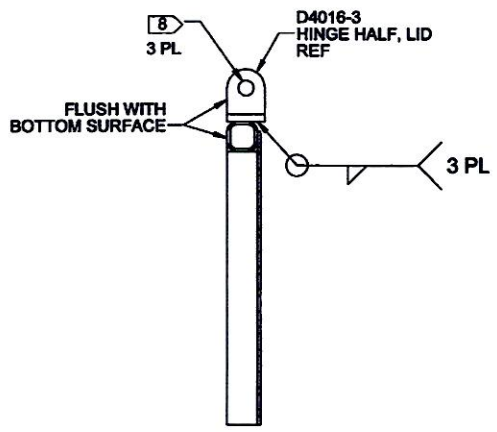
B	REVISE -101 (ZN B4-7, D3-7)	RF	17.02.09
A	NEW ISSUE	RF	15.08.10
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5336	SHEET 1 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DSS	R66/R44 BASKET LID ASSY	NTS
DATE	17.02.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
2017-03-22
ECN 17-535

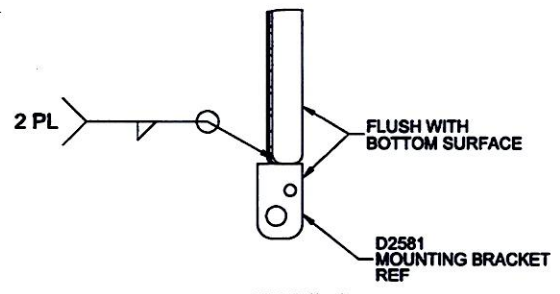
APPROVED



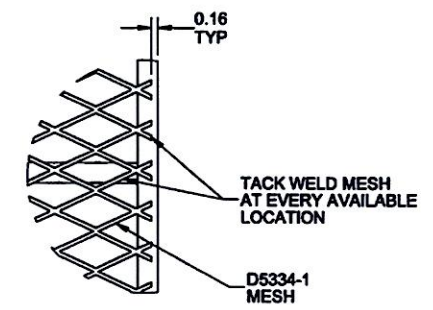
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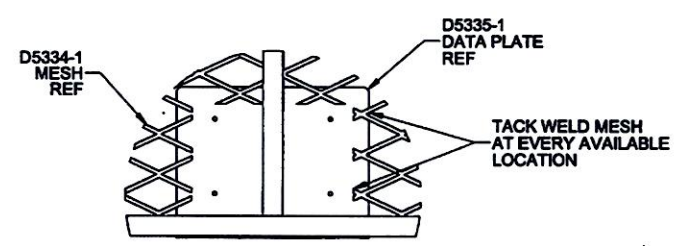
SECTION A-A
D6-2



DETAIL C
B3-2



DETAIL D
C3-2



DETAIL B
B2-2

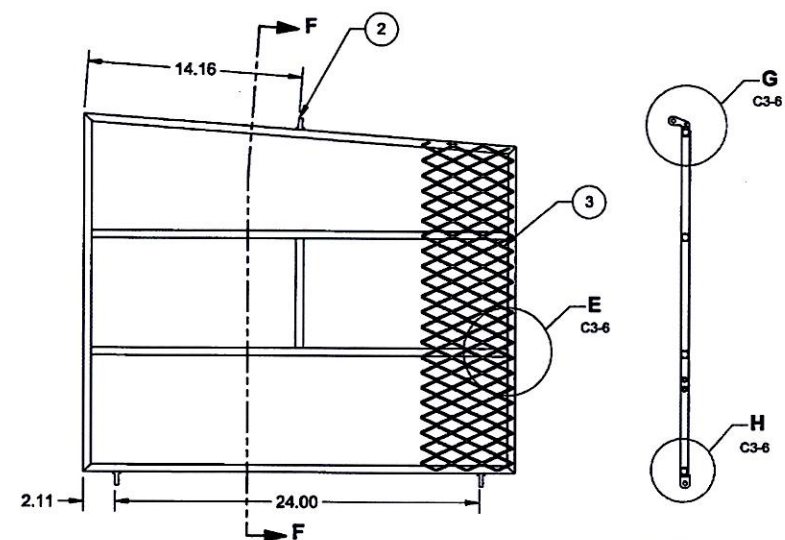
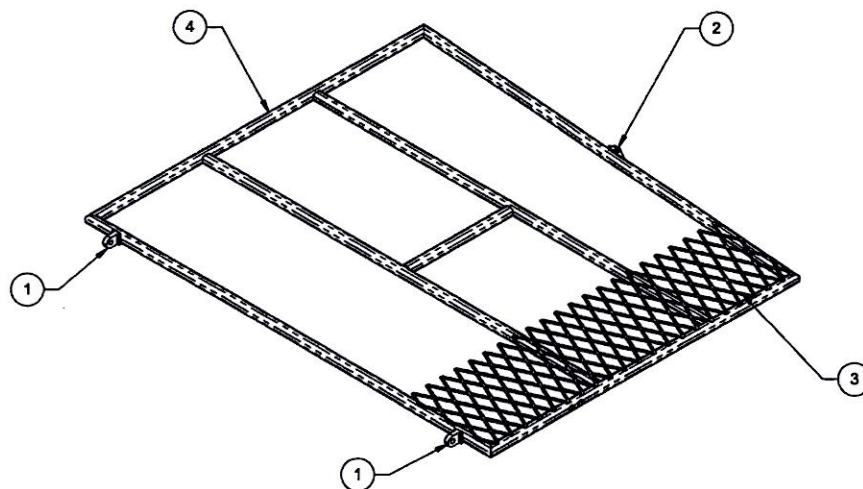
RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5336	REV. B
MFG. APPR.	DD	SHEET 3 OF 8	
APPROVED	HS	TITLE	SCALE
DE APPR.	D5	R66/R44 BASKET LID ASSY	NTS
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8 7 6 5 4 3 2 1

ITEM	QTY	P/N	DESCRIPTION
	X	D5336-043	BASKET LID ASSY, LH
1	2	D4016-3	HINGE HALF, LID
2	1	D5333-1	LOCKING BRACKET
3	1	D5334-3	LID MESH
4	1	D5336-103	TUBULAR ASSEMBLY, LID



SECTION F-F

D5336-043 BASKET LID ASSY, LH
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 6.4 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5336-043
- 10) WELD PER DART QSI 004

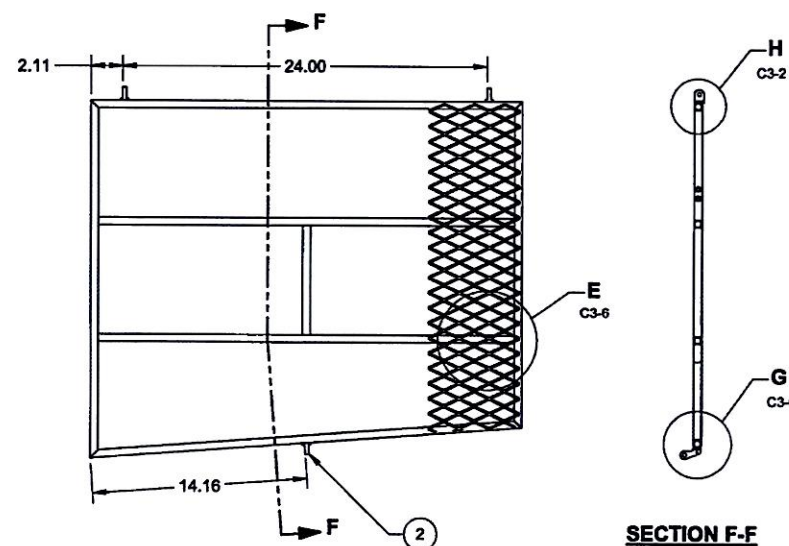
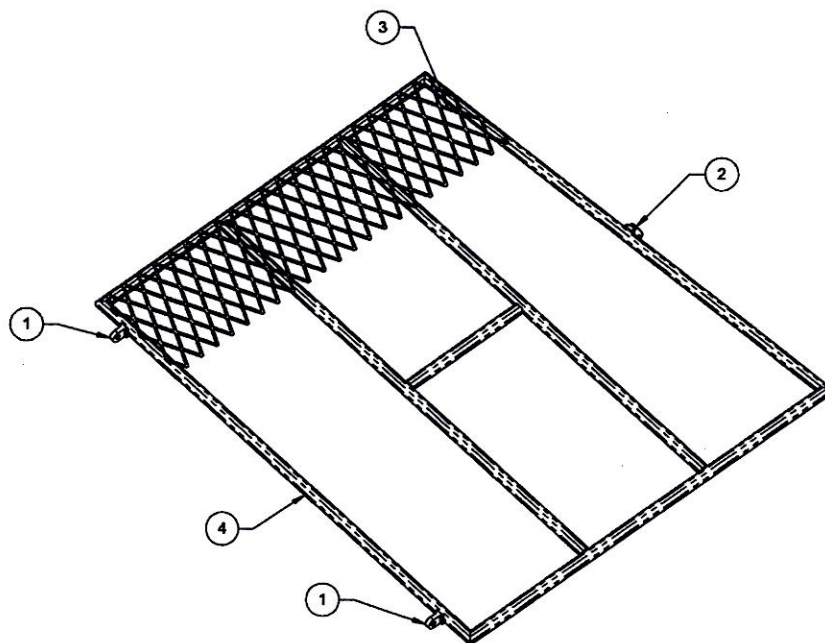
RELEASED
2017-03-22

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5336	REV. B
MFG. APPR.	DD	TITLE R66/R44 BASKET LID ASSY	SHEET 4 OF 8
APPROVED	HS	SCALE	NTS
DE APPR.	DS	DATE 17.02.09	

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ITEM	QTY	P/N	DESCRIPTION
	X	D5336-044	BASKET LID ASSY, RH
1	2	D4018-3	HINGE HALF, LID
2	1	D5333-1	LOCKING BRACKET
3	1	D5334-3	LID MESH
4	1	D5336-103	TUBULAR ASSEMBLY, LID



D5336-044 BASKET LID ASSY, RH
(MESH SHOWN LOCALLY FOR CLARITY)

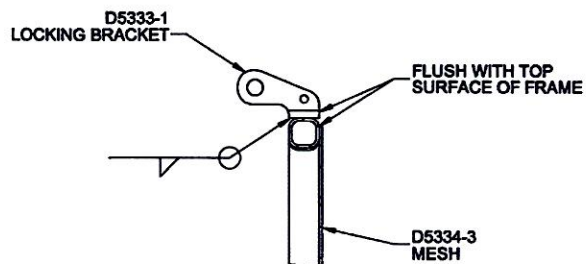
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 6.4 lbs
- 8) MASK HOLES PRIOR TO FINISHING
- 9) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.06 UNLESS OTHERWISE NOTED FOR D5336-044
- 10) WELD PER DART QSI 004

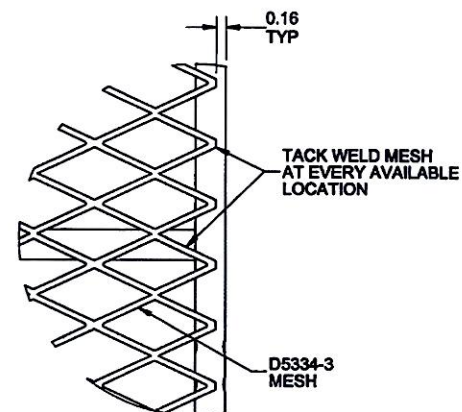
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2017-03-22

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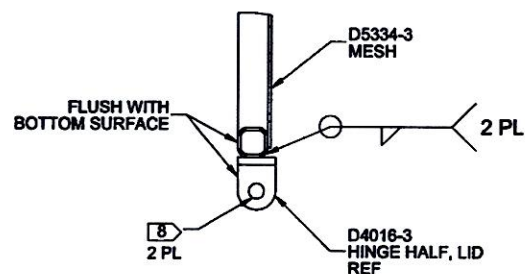
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5336	REV. B
MFG. APPR.	DD		SHEET 5 OF 8
APPROVED	HS	TITLE R66/R44 BASKET LID ASSY	SCALE NTS
DE APPR.	DS		
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DETAIL G
(-043 SHOWN, -044 OPPOSITE)
C1-4
B1-5



DETAIL E
C2-4
C2-5

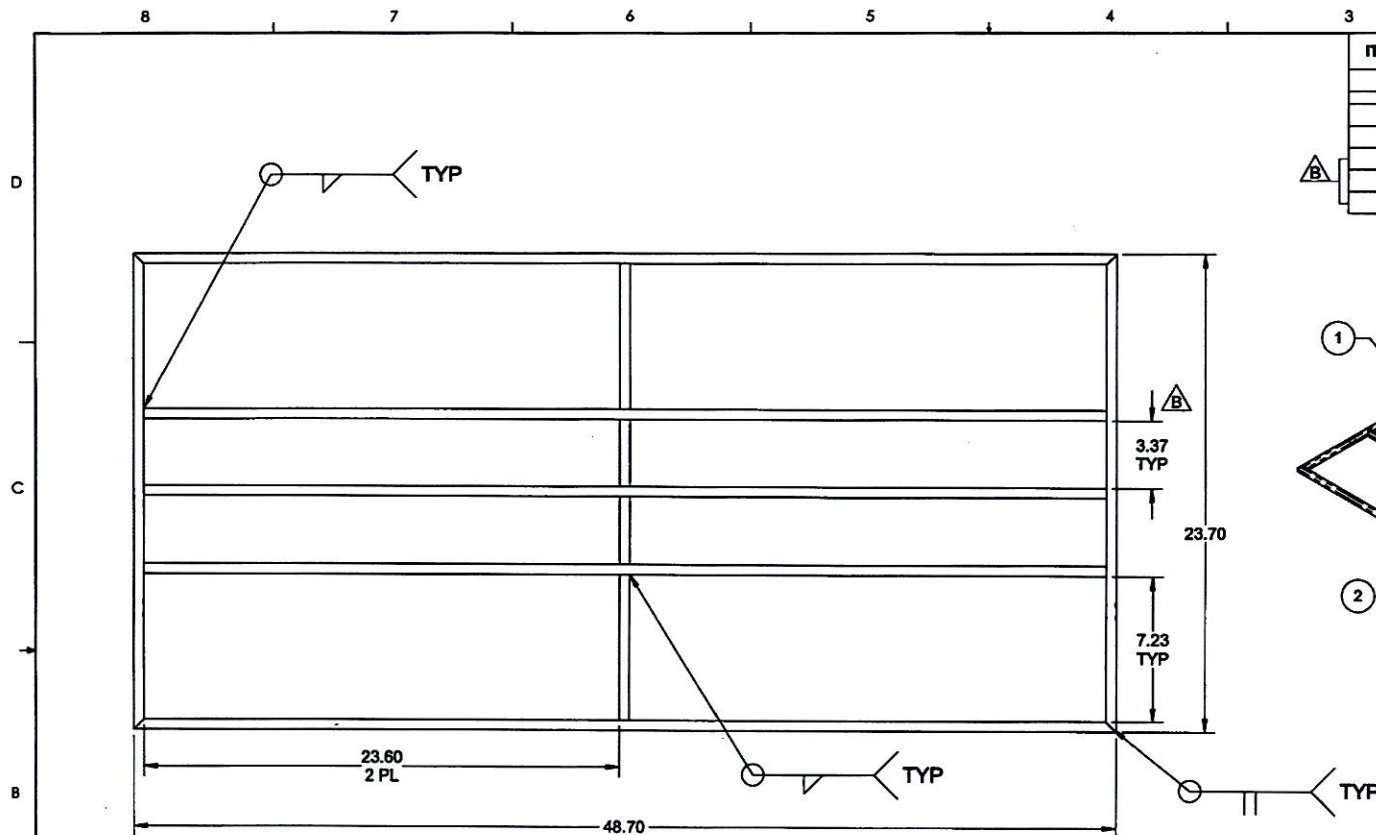


DETAIL H
(-043 SHOWN, -044 OPPOSITE)
B1-4
C1-5

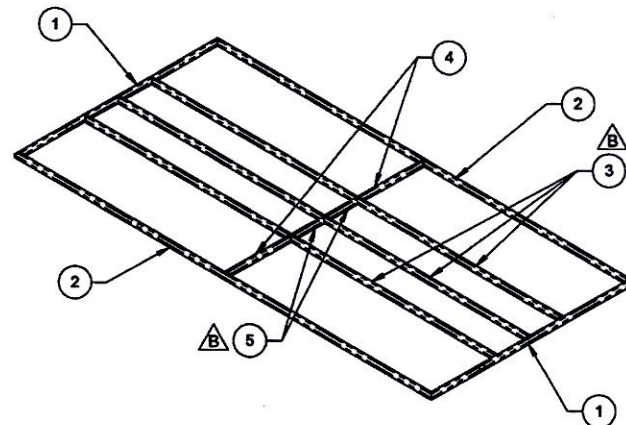
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2017-03-22

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5336	REV. B
MFG. APPR.	DD	SHEET 6 OF 8	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D5336-101	TUBULAR ASSEMBLY, LID
1	2	D5332-041	RIB ASSEMBLY
2	2	D5332-1	RIB
3	3	D5332-13	RIB
4	2	D5332-15	RIB
5	2	D5332-19	RIB



D5336-101 TUBULAR ASSEMBLY, LID

NOTES:

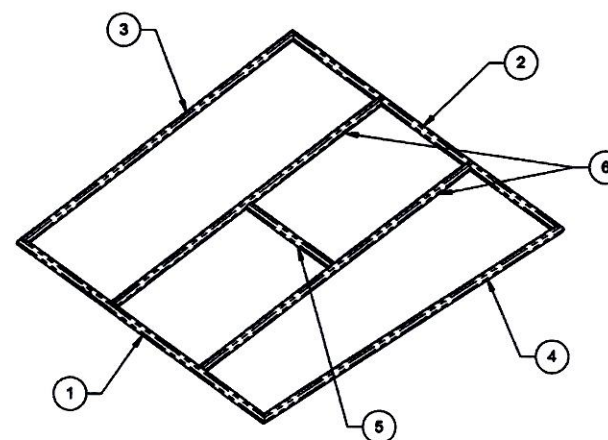
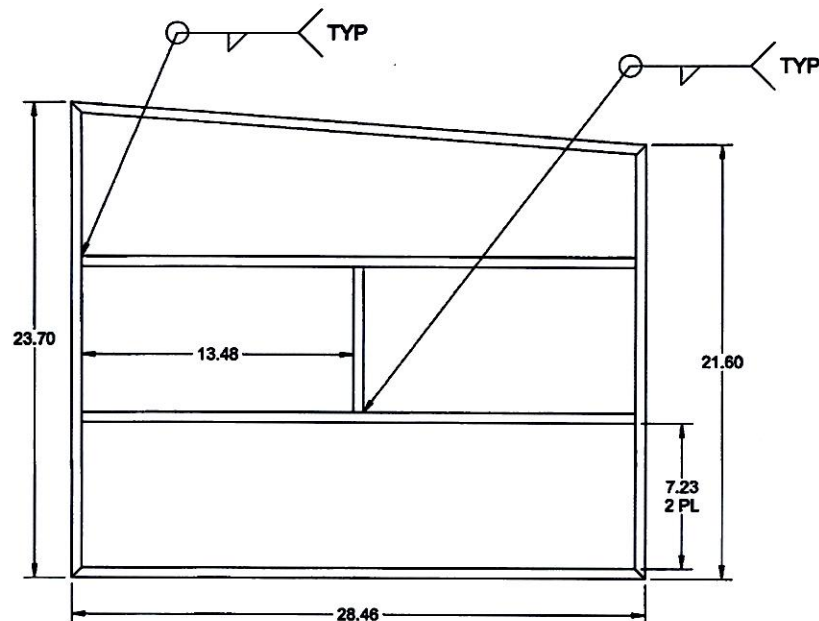
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 6.78 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5336-101
- 9) WELD PER DART QSI 004

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2017-03-22

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D5336	REV. B
MFG. APPR.	DD		SHEET 7 OF 8
APPROVED	HS	TITLE R66/R44 BASKET LID ASSY	SCALE NTS
DE APPR.	DS		
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ITEM	QTY -103	P/N	DESCRIPTION
	X	D5336-103	TUBULAR ASSEMBLY, LID
1	1	D5332-043	RIB ASSEMBLY
2	1	D5332-7	RIB
3	1	D5332-9	RIB
4	1	D5332-11	RIB
5	1	D5332-15	RIB
6	2	D5332-17	RIB



D5336-103 TUBULAR ASSEMBLY, LID

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.58 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS IS ± 0.100 UNLESS OTHERWISE NOTED FOR D5336-103
- 9) WELD PER DART QSI 004

RELEASED
2017-03-22

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DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	DD	D5336	SHEET 8 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	R66/R44 BASKET LID ASSY	NTS
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